



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3812
Job Sheet 168024



Part No: 646.3812

Job Qty: 8 ea

Part Name: Gusset Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/24/17

Created By: Linda Lacelle

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		11/23/17	0.00	0.00	Start Up Machining		J.C.-L. 17-12-11
100	Bandsaw	8 pcs		11/23/17	0.00	1.86	Bandsaw1		J.C.-L. 17-12-11
110	Mill Conv	8 pcs		11/24/17	0.00	3.76	Mill Conv 1		J.C.-L. 17-12-12
120	QC	8 pcs		11/24/17	0.00	0.00	QC2		J.C.-L. 17-12-12
130	QC	8 pcs		11/24/17	0.00	0.00	QC8		FK 17-12-12
140	Outsource	8 pcs		11/24/17	0.00	0.00	Outsource4		12/1/18
150	Packaging	8 pcs		11/24/17	0.00	0.00	Packaging2		12/1/18
155	QC	8 pcs		11/24/17	0.00	0.00	QC5		PD 18-01-17
180	Packaging	8 pcs		11/24/17	0.00	0.00	Packaging3	CCK 105	SJ
190	QC21-SA	8 Ea		11/24/17	0.00	0.00	QC21		

Part Op 110 - 1-Machine per DWG

Descriptions: 140 - Issue P/O to ATG : _____

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

JAN 17 2018
21
9-09

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation 1.594'	M7075T6A0.75X0.75X0.060X0.062	1	51	0	0

Part Specifications

Specifications could not be found.

Plex 11/9/17 3:10 PM dart.lacelle.linda

DART
AEROSPACE
S019903

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Gusset Bracket

PART NO: 646.3812
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/11/17
Job No: 168024

DART
AEROSPACE
S019903

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Gusset Bracket

PART NO: 646.3812
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/11/17
Job No: 168024

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03697				SHEET 1 OF 1	
	DWG NO. 646.3800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/14/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: BRACKETS					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL.				ECR: D-12-006	

IS

⚠ PRIMARY MATERIAL: 7075-T651 ALUMINUM PER AMS-QQ-A-250/12.
ALTERNATE MATERIAL: 7075-T6511 ALUMINUM PER AMS-QQ-A-200/11.

SHEET 1, ZONE A2 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168024

DAS
30
9-89

NOV 13 2017

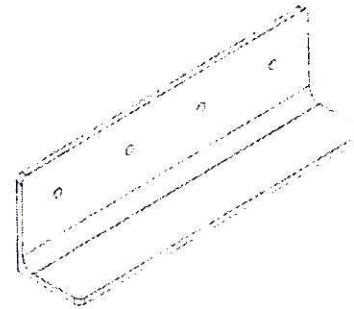
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

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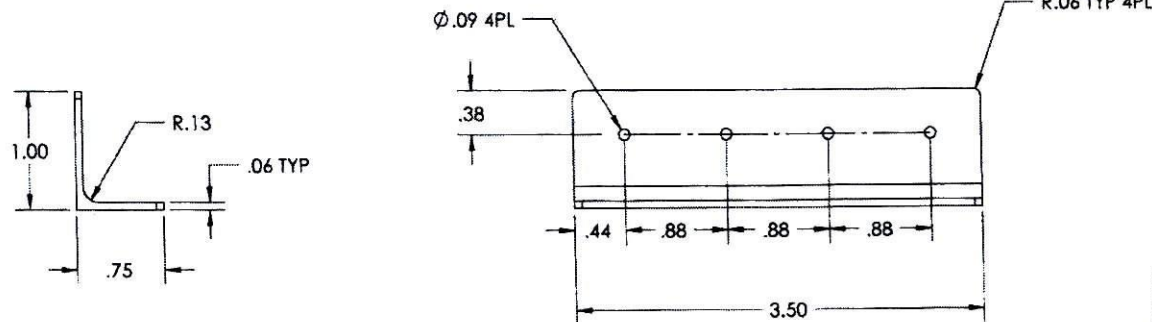
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

NOTES:

1. MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



646.3810



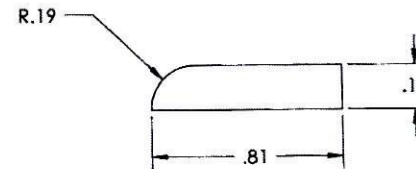
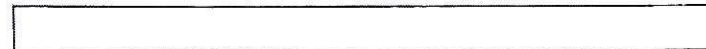
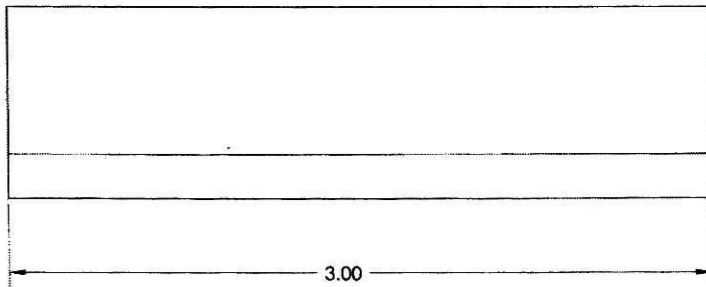
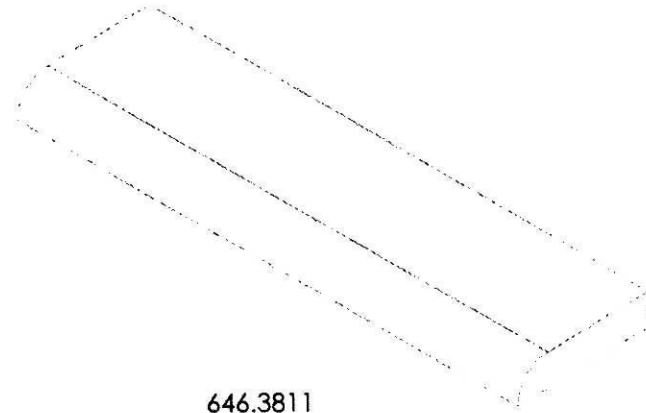
UNINCORPORATED ECU(S)

03697

	646.3814	WIPER BRACKET	△	△		
	646.3813	STRUT BRACKET	△	△		
	646.3812	GUSSET BRACKET	△	△		
	646.3811	RADIUS BLOCK	△	△		
	646.3810	BRACKET	△	△		
	QTY	FIN D #	PART #	DESCRIPTION	MATL	SPEC.
PARTS LIST						
QTY						
NEXT ASSY (S)		APICAL INDUSTRIES				
646.4000		2608 TEMPLE HEIGHTS DR.				
		OCEANSIDE, CA. 92056-3512 (760)724-5300				
		BRACKETS				
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		SIZE 1/8" X 3/16" X 1/8"	DWG NO 646.3800	REV N/C
		TOLERANCES ARE		SCALE NONE		
		3 PLACE DECIMALS ±.010				
		2 PLACE DECIMALS ±.005				
		ANGLES ±.5°				

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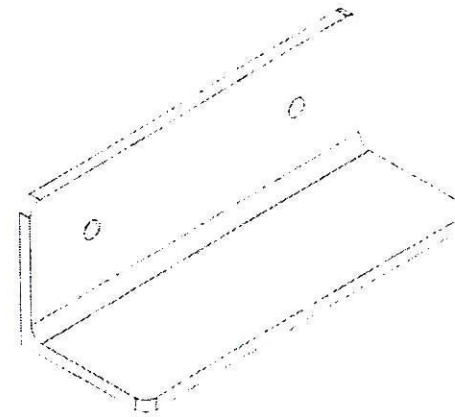
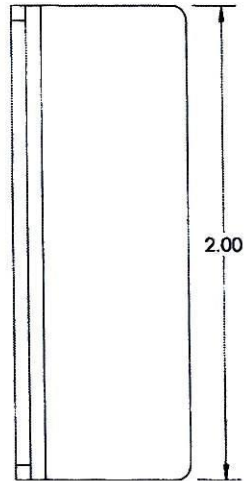
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



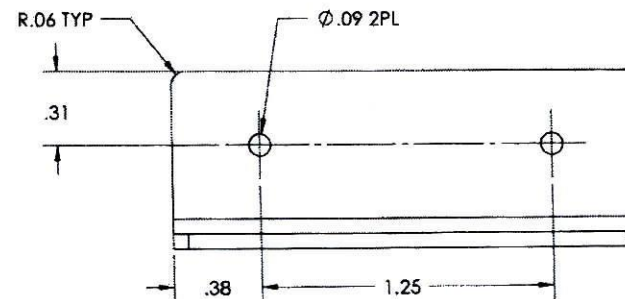
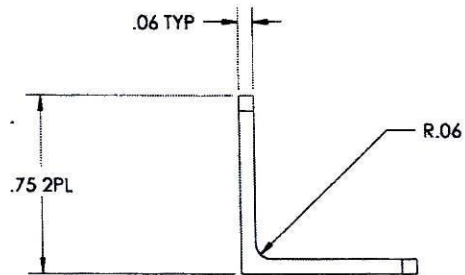
NEXT ASSY (S)		DRAWING DATE: 08-19-08		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
DRAWN BY: J. CARDNER		CHECKED:					
DRAWING APPROVAL:		CONTRACT NO:					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ±.5°		GET CASE CODE: B		DWG NO: 646.3800			
SCALE: NONE				SHEET 2 OF 5			

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



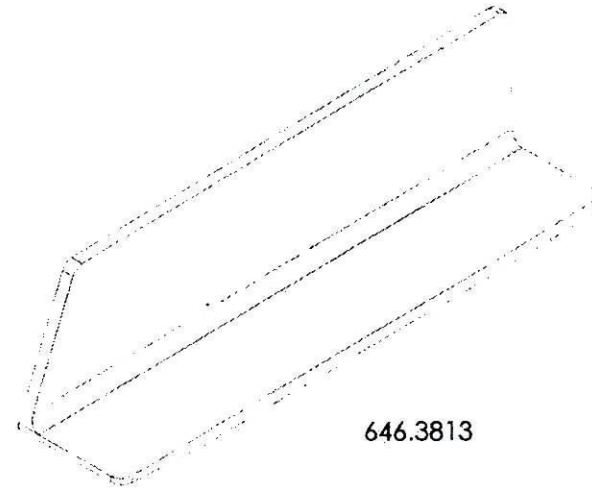
646.3812



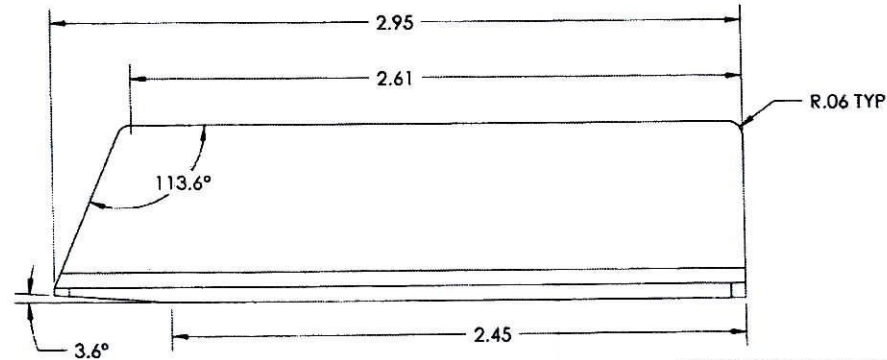
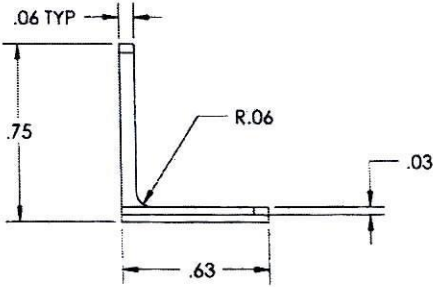
NEXT ASSY (S)		ORIGINAL DATE 08/19/08	APICAL INDUSTRIES	
DRAWN BY		CHECKED	2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL			OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.			BRACKETS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SHEET NO. 07/26	DWG. NO. 646.3800	REV. N/C
		SCALE: NONE		SHEET 3 OF 3

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



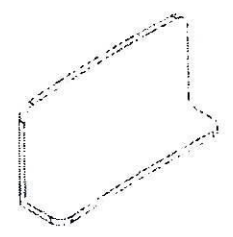
646.3813



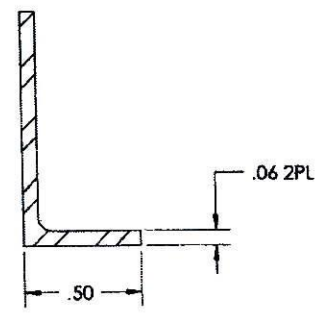
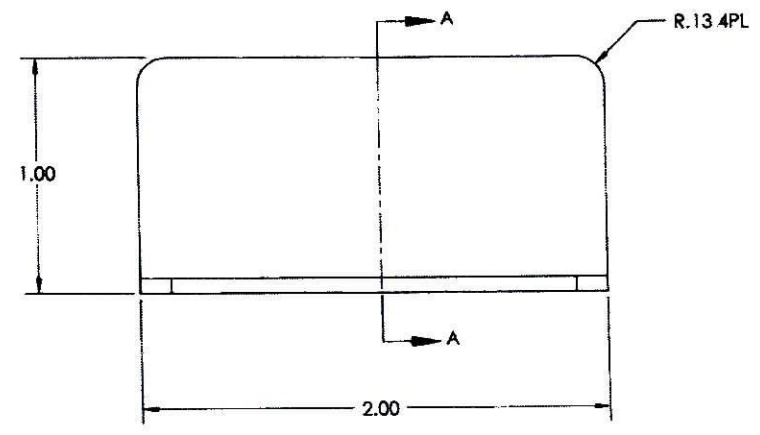
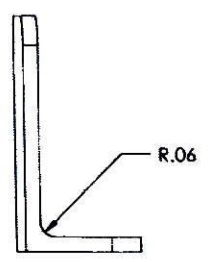
NEXT ASSY (S)		ORIGINAL DATE 08-19-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 BRACKETS	
		DRAWN BY J. GARDNER		
		CHECKED BY 		
		DRAWING APPROVAL 		
		CONTRACT NO. 		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.010 2 PLACE DECIMALS ±.005 ANGLES ± 1°		SET B	CAGE CODE 07M26	QND NO. 646.3800
SCALE NONE		SHEET 4 OF 5		REV. N/C

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REV.	DESCRIPTION	DATE	APPROVED



646.3814



SECTION A-A

NEXT ASSY (S)	ORIGINAL DATE	08-19-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
	DRAWN BY	10/08/08		
	CHECKED BY	10/08/08	BRACKETS	
	DATE	10/08/08		
UNLESS OTHERWISE SPECIFIED			SCALE	NONE
DIMENSIONS ARE IN INCHES			SHEET	5 OF 5
2 PLACE DECIMALS 2.00			REV	N/C
3 PLACE DECIMALS 2.000			DATE	07/26/08
ANGLES 1° 5'			QTY	646.3800

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038682

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038682
PO Date: 12/19/17
Due Date: 1/5/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
DEC 21 2017

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169179	649.4814	Doubler ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)	Firmed	1/17/18	10 pcs	0 pcs	10 pcs	\$7.25/pcs	\$72.50
2	168024	646.3812	Gusset Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	1/17/18	8 pcs	0 pcs	8 pcs	\$7.10/pcs	\$56.80
3	168250	646.3810	Bracket Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3800	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$7.55/pcs	\$37.75
4	168252	646.3812	Gusset Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$7.10/pcs	\$35.50
5	169178	649.4812	Shim ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)	Firmed	1/17/18	20 pcs	0 pcs	20 pcs	\$13.15/pcs	\$263.00
6	168253	646.3813	AS350 Strut Bracket Issue P/O to ATG :	Firmed	12/22/17	5 pcs	0 pcs	5 pcs	\$7.10/pcs	\$35.50



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914369

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 615-632-9377 Fax: 615-632-9377		OUR TRUCK	
Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 649.4814 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22189		Rev: D PO: PO038682 Line: 1
4 ea	Part: 646.3814 Wiper Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22202		Rev: N/C PO: PO038682 Line: 14
8 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22190		Rev: N/C PO: PO038682 Line: 2
5 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22191		Rev: N/C PO: PO038682 Line: 3
5 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22190		Rev: N/C PO: PO038682 Line: 3
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914369

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 22192	PO: PO038682	Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>05/01/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>SP18-01-11</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			